



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-4-4

Job Sheet 176358



Part No: C3-4-4

Job Qty: 6 ea

Part Name: Load Beam



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/20/18

Job Tracking No:

Due Date: 4/27/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG C3-4-4A/C3-4-4KA Rev 10 IPP Rev A 18.03.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		4/27/18	0.00	0.00	Start Up Waterjet2		Done 18/05/18 Done 18/05/18
100	Waterjet	6 pcs		4/27/18	0.08	1.00	Waterjet 2 OMAX		
120	CNC Vertical Machining	6 pcs		4/27/18	2.00	3.00	MORI NV5000-1		
130	QC	6 pcs		4/27/18	0.00	0.00	QC2 Machining-5		
140	QC	6 pcs		4/27/18	0.00	0.00	QC8 Machining-5		
150	Outsource	6 pcs		4/27/18	0.00	0.00	Outsource1		
152	Outsource	6 pcs		4/27/18	0.00	0.00	Outsource15		
160	Packaging	6 pcs		4/27/18	0.00	0.00	Packaging2		
170	QC	6 pcs		4/27/18	0.00	0.00	QC6		
180	Packaging	6 pcs		4/27/18	0.00	0.00	Packaging3-2		
190	QC21-SA	3 6 Ea		4/27/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut C3-4-4 blank (CANAM FOLDER) Dwg Rev: 10 Prog Rev: 10 2-Deburr if necessary
Descriptions: 120 - 1-Machine as per folio FB FOLIO REV: DWG REV: 2-Deburr

MACHINE ENGRAVE AS PER DWG

150 - 1-Issue P/O to Metcore; P/O RC 53-56 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

152 - -Issue P/O to Groupe Altech: P/O -Nickel plate, QQ-N-290, Class 2, Grade C -Nickel Plate .0009-.0011 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-1.000X10.000	AISI 4140 Steel Sheet/Plate	1500 ft (125 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140-S-1.000X10.000	0	1	0

Part Specifications

Specifications could not be found.

Plex 4/20/18 3:20 PM Dart.Gagnon.Michelle

0.19 94732

DART
AEROSPACE

Container No: S069002



Part: C3-4-4

Job No: 176358

Serial No/Batch: S069002

Inspector:

Date: 05/07/18

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☒ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : <u>18-06-05</u>	Step #: <u>100</u>	QTY Effective : <u>(2)</u>		MRB (QSI042) Approval DAS 9 9-89 <u>18-06-05</u>	
Description Work Order Deviation		Disposition		Completed By	
wrong program was used to cut C3-4-4. Sequence 100 said to cut C45-44. R.C.		Scrap destroy. Material is too thin to use as a C45-44 Make changes to Route		Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-06-05</u>	
QC / QA Coordinator Approval DAS 9 9-89 <u>18-06-05</u>					

Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☒	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☒	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER : _____			